

Work Order ID 73075

Thursday, August 25, 2011 11:10:52 AM



Aug. 30th

Page 1

Item ID:	D4054-009	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Tube Assembly					
Start Date:	8/25/2011	Start Qty: 4:00		Cust Item ID:		
Required Date:	8/30/2011	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	<i>MF</i>	Date:	<i>11-08-25</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4054	A								
100	Small Fab	0.00							
	Small Fab								
	Memo	0.00							
	Bend tube as per Dwg D4054								
	Install sleeves and nuts								
	Flare ends as per Dwg D4054.								
			<i>SB 11/08/30</i>						<i>(6)</i>
110	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
	Memo	0.00							
	Quality Control		<i>8/11/08/30</i>						<i>(46)</i>

SB 11/08/30 (6)

(6)

(46)

Work Order ID 73075

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Item ID: D4054-009

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube Assembly

Start Date: 8/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/30/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



Packaging

Identify as per dwg & Stock Location: 8F-193

0.00

Memo

0.00

Packaging

11-08-30

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/8/3011-08-30

Picklist Print

Thursday, August 25, 2011 11:10:48 AM

Page 1

Work Order ID: 73075

Parent Item: D4054-009

Parent Item Name: Tube Assembly




Start Date: 8/25/2011

Required Date: 8/30/2011

Start Qty: 4.00

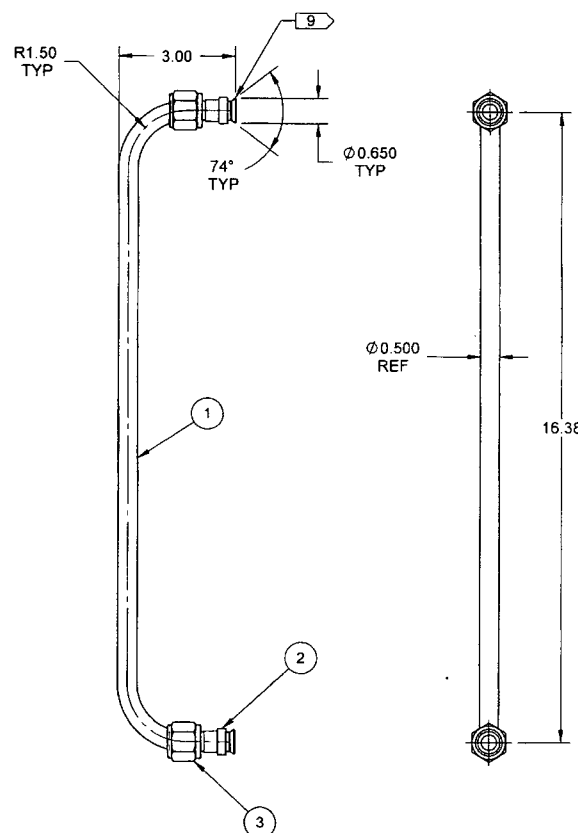
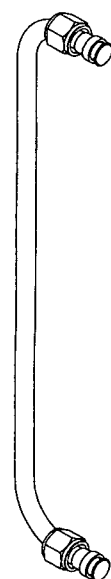
Required Qty: 4.00

Comments: IPP rev A 10.01.19 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN818-8D  Nut		Purchased	No			100	Each	18.0000	1	4		8/25/08/30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST321		10							
				118112		10							
				ST331		8							
				115594		3							
				117514		5							
*M6061T6T0.500W.049  6061-T6 RD Tube .500 x.049W		Purchased	No			100	f	301.3512	0.55	2.315789		8/25/08/30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT014		301.351211							
				117270		301.351211							
MS20819-8D  Sleeve		Purchased	No			100	Each	30.0000	1	4		8/25/08/30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST323		30							
				114544		30							

M111944 (4x)
M111028 (2x)

ITEM NO.	QTY -001	P/N	DESCRIPTION
1	X	D4054-001	TUBE ASSEMBLY
2	2	MS20819-8D	SLEEVE
3	2	AN818-8D	NUT



D4054-001 TUBE ASSEMBLY

NOTES:

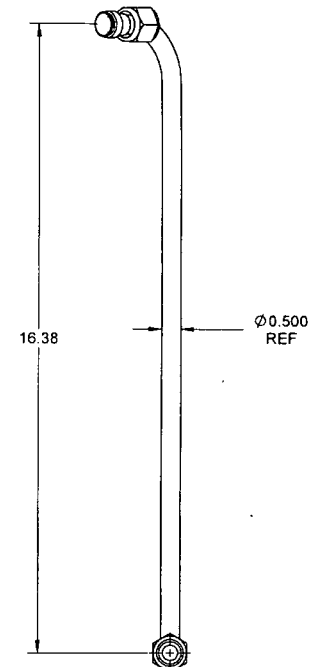
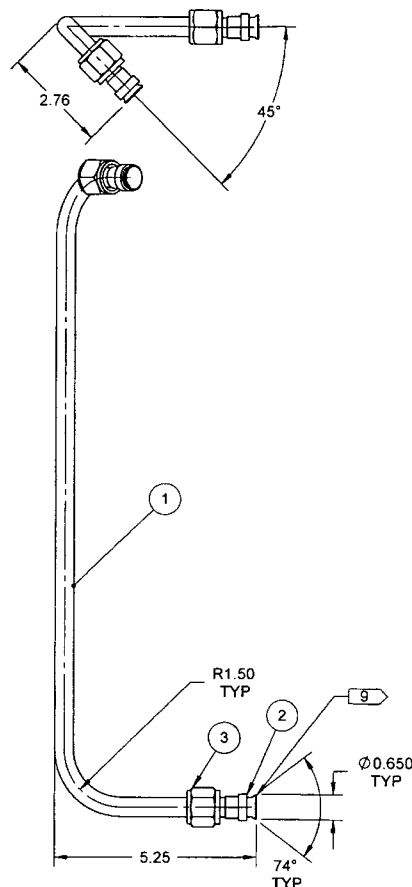
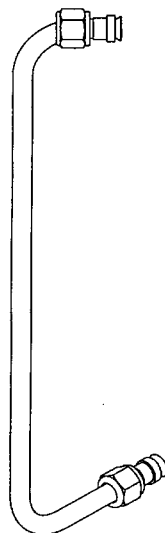
- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-001" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.20 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-001T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

73075

RELEASED
2010-01-14
MD

REV.	NEW ISSUE	RF	09.12.30
DESIGN	RF	BY	DATE
DRAWN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF		
MFG. APPR.	RF	DRAWING NO.	REV. A
APPROVED	RF	D4054	SHEET 1 OF 3
DE APPR.	RF	TITLE	SCALE
DATE	09.12.30	TUBE ASSEMBLIES	NTS
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ITEM	QTY -003	P/N	DESCRIPTION
1	X	D4054-003	TUBE ASSEMBLY
2	2	MS20819-8D	SLEEVE
3	2	AN818-8D	NUT



73075

RELEASED
2010-01-14
MP

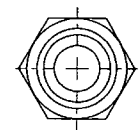
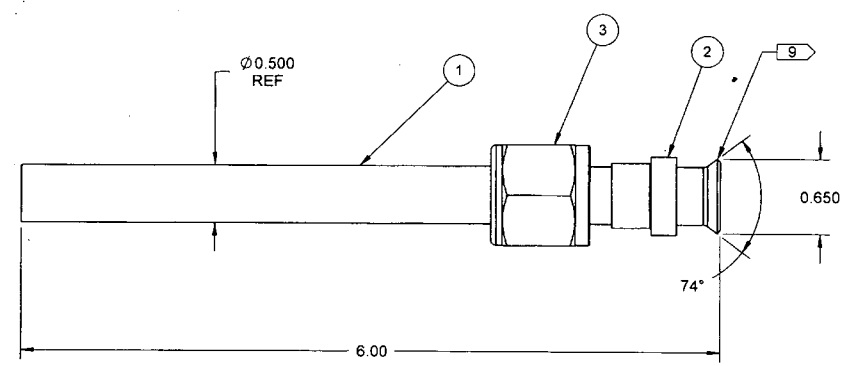
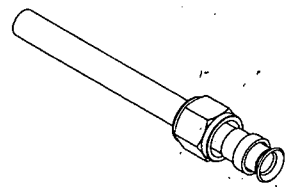
NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER VW-T-700/6
REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-003" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.21 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-003T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

D4054-003 TUBE ASSEMBLY

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4054	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE ASSEMBLIES	NTS
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ITEM	QTY .009	P/N	DESCRIPTION
1	X	D4054-009	TUBE ASSEMBLY
2	1	MS20819-8D	SLEEVE
3	1	AN818-8D	NUT



D4054-009 TUBE ASSEMBLY

#73075

RELEASED
2010-01-14

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER VVV-T-700/6
REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-009" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-009T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS
- 10 ENSURE SEAMLESS TUBING IS USED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4054	SHEET 3 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TUBE ASSEMBLIES	NTS
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